

Work Order ID 127826

December-17-14 1:56:18 PM

127826

Page 1

Item ID: D4407-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 12/16/14 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 14-12-18 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4407	C

100 0.00 ***100*** DAS 44 14/12/17
 Cold Saw 0.00 11 Ø 9-89
 Hyd Mech Memo Cut blanks at 58.75"

110 0.00 ***110*** DAS 20 14-12-23
 HAAS 1 0.00 11 Ø 9-89
 HAAS CNC vertical machine #1 Memo
 1-Mill as per folio FB082 & dwg D4407,
 FOLIO REV: C
 DWG REV: C

2-Deburr as required

EXTRA MATERIAL WILL BE CUT AT ASSEMBLY (D4406-043)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/16/14 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 12/17/14 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									DAS
QC									20
Quality Control	Memo	0.00				11	0		14-12-23 9-89
130	QC8- Inspect parts - second check	0.00							
130									
QC									
Quality Control	Memo	0.00				11	0		
140	Identify as per dwg & Stock Location: <u>WA001</u>	0.00							
140									
Packaging									
Packaging	Memo	0.00				x 11		15-01-06	MAH

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Work Order ID 127826

December-17-14 1:56:18 PM

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Page 3

Item ID: D4407-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Bar

Stop ***NS2***

Start Date: 12/16/14 Start Qty: 12.00

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Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 12.00

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
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Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

15/1/6

B-1-6

DQA: _____ Date: _____



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Picklist Print

December-17-14 1:56:18 PM

Page 1

Work Order ID: 127826

127826

Parent Item: D4407-3

D4407-3

Parent Item Name: Bar

Start Date: 12/16/14

Required Date: 12/17/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP revA 11.06.06 new issue EC verified by:DD
12/02/13 new issue JFS verified by:JLM

IPP revB

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	88.4160	4.843	61.17474			
M304B0 250x0 500													
304 BAR .250 x .500													

DAS
44
9-89

14/12/22

Location

Loc Qty

Loc Code

MAT009

88.416

m129366

88.416

Steel

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

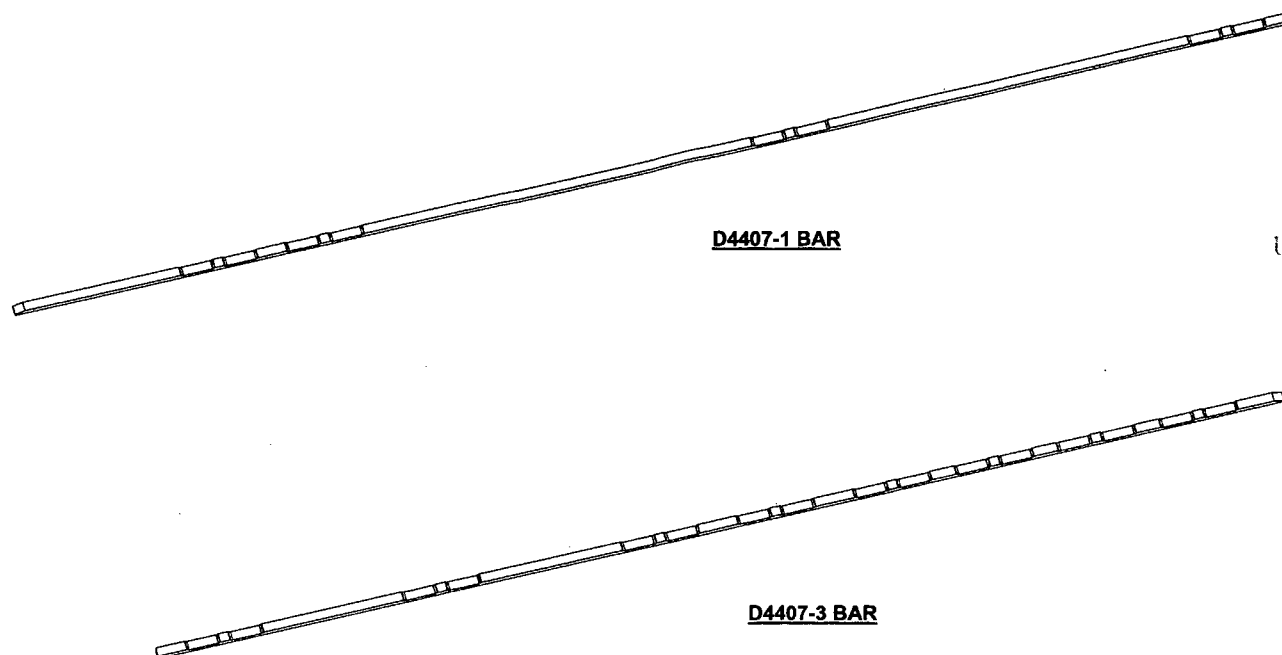
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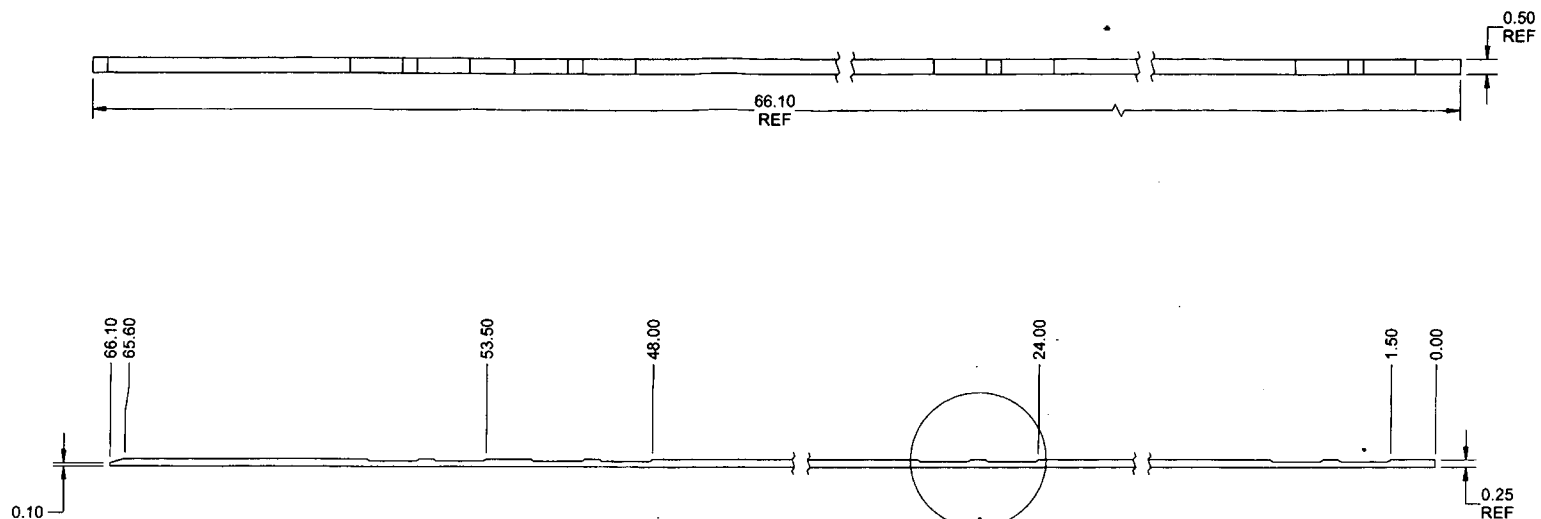
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 127826 MJS

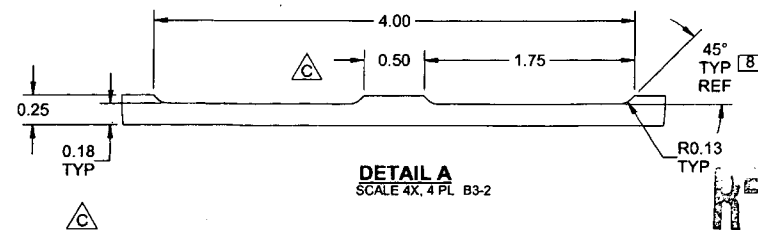
14-12-18

RELEASED
Jd 2013-03-21
mo

C	REDESIGNED WITH SHORTER CUTS. NOTE 8 ADDED. B4-2, B4-3 0.16 WAS 0.13 (REF NCR12-2031)	AJS	13.03.11
B	REMOVE TOOLING HOLES FOR -1/3; RE-DESIGN D4407-3	RF	12.01.30
A	NEW ISSUE	RF	11.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4407	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BAR	NTS
DATE	13.03.11	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4407-1 BAR



DETAIL A
SCALE 4X, 4 PL B3-2

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL, 0.250 x 0.500 BAR
PER ASTM A276 OR ASTM 240
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: = 2.25 lbs
- 8) ANGLE TO BE DETERMINED BY AVAILABLE TOOLING

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4407	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
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RELEASED
2013-03-21

